Work Order ID 115142 Monday, March 17, 2014 2:48:44 PM			*115					Page	1			
Item ID: D364: Revision ID: Item Name: Cover	1-3		Accept	*N900	040	100)*	Setup	Start Stop	171	S1* S2*	
Start Date: 3/17/1 Required Date: 3/17/1 Reference:	~ *	*6* *6*		Cust Item 1 Customer:								
	ess Plan:	Date: 14-03-1			ate:			Run	Start Stop	"I/J	R1*	
QC: Sequence ID/ Work Center ID	Operation Description	_ Date:	SPC (Y/N): Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Re		Reject Number	R2* Insp. Stamp	
Draw Nbr	Revision Nbr						C -7		,			
D3641	Rev C											
100 *1 \\ Waterjet FLOW CNC Waterjet	FLOW WATER JET Memo 1-Cut as pe	r Dwg D3641	0.00				8		<u> </u>		DAS 23 9-89	
5052 .037	Dwg Rev:_ Prog Rev:_ 2-Deburr if	<u> </u>									DAS	
*110 *110*	QC2- Inspect parts off n	nachine FAI/FAIB	0.00				8				23 9-89	14-09.
QC Quality Control	Мето		0.00									
¹²⁰ *1 2 ∩*	QC8- Inspect parts - sec	ond check	0.00				Z				Dr. 38	14-9-4

0.00

Memo

Quality Control

DQA:			Date:									*ve	TOACT
						WORK ORDER NON-	-CC	ONFO	RMANCE / UF				AEROSPACE
QA Closed:			Date:							W	ork Order up	date only	
Work Orde	er:					DISPOSITION				AGAINST D	PARTMENT	PROCESS	
***************************************	٠	 				Rework			Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	۱o.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	•					Use-as-is		Thern	noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR N	No.					Suspected Unapproved			Large Fab	Composite		Supplier	
Post			T		Doss	rintian of work order undate		Initial	Acti	ion	Sign 9.		
Root Cause		Date	Step	Qty	Desci	ription of work order update or non-conformance		nief Eng	Descri		Sign & Date	Verification	QC Inspector
Design		Date	Step	Qty		or non comormance		iici Liig	Descri	iption	Date	Vermedion	QC IIISPECTOI
Doc/Data													
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Offset/Setup									·				
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Unapproved													
Ç							FA	ULT CAT	regory				
Landi	ng (Sear				General		,		_	- ,	_	· ¬
		Bending				Bend		1	Program		Outside Dim	<u> </u>	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain		_	Over/Under		Set-up
		Cracks			<u> </u>	Broken/Damage/Defect		Hardwa		<u> </u> _	Part Incorred	<u> </u>	Temperature/Cure
•		Crimp/Kir	nk/Ripple	/Wave	_	Burrs	_	i i	ion Incomplete/Un	· –	Part Lost/Mi	ssing	Weld
		Cuffs			-	Contamination		-4	ions Incomplete/U	Inclear	Part Moved		Wrong Stock Pulled
		Crushing				Countersink		-	ned/off center		Positioned V		- .
,		Heat Trea			<u> </u>	Cut Too Short	<u>L</u> .	Mislabe			Power Loss/	Surge	Other
		Inspection		Tube		Drawing	_	Misread					<u> </u>
		Marks/Ch				Drill Holes		Off-set					
		Turning S			<u> </u>	Finish	_	4	Calibration				
		Wave/Tw	ist in Tub	oe		Fit/Function		Out of 9	Sequence				

Work Ord Monday, March				*115			Page 2					
Item ID: Revision ID: Item Name:	D3641-3 Cover			Accept	*N900	<u>040</u>	100) *	Setup	Start Stop	1 71	S1* S2*
Start Date: Required Date: Reference:	3/17/14 : 3/17/14	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item I Customer:	D:						
Approvals:	Process Pl	an:	Date:	Tooling:	Da	ate:	-	J	Run	Start	*N	R1*
	QC:		Date:	SPC (Y/N):	Da	ate:				Stop	*N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
120 Brake NC		NC BRAKE Memo Form as per	Dwg D3641-3	0.00		DAS 30 9 #9		8				14109
¹⁴⁰ *1⊿∩ *		QC5- Inspect part comple	eteness to step on W/O	0.00				8				DAS 38 9-89 /4-9
QC		Memo		0.00								

150

Chemical Conversion Coat per QSI005 4.1

0.00

150 HandFinish

Quality Control

Memo

0.00

8 2614.8.10

Hand Finishing

DQA:		Date	:								•	DART
					WORK ORDER NON	-CO	ONFO	RMANCE / UPDATE				AEROSPACE
QA Closed:		Date	:		·				W	ork Order u	odate only]
Work Orde	er:				DISPOSITION			AGAINST	DE	PARTMENT	/PROCESS	· ·
					Rework]		Skid-tube Crosstube]	Water Jet	Engineering
Part N	lo				Scrap	1		Machining Small Fab		Pro	d. Eng. Coor.	Quality
					Use-as-is]	Therr	moforming Finishing		Rec/Sto	re/Packaging	Other
NCR N	lo		· <u>·</u>		Suspected Unapproved]		Large Fab Composite	e Supplier			J
Root				Desci	ription of work order update		Initial	Action		Sign &		
Cause	Dat	e Step	Qty		or non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector
Design												
Doc/Data	_										}	
Equip/Tooling										}		
Handling/Pre												
Material			'									
Operator	_											
Offset/Setup	_											:
Process	┙.											
Supplier												
Training				:								
Transport								,				
Unapproved			<u> </u>	<u> </u>				TECODY				
Landie	ng Gear				· · · · · · · · · · · · · · · · · · ·	FAI	ULT CA	TEGORY				
Lanun	Bend	na .			General Bend	<u> </u>	الحمانه (ر	Program	$\overline{}$	Outside Dim	onsions [Pressure/Forced
		ਾਫ e Not Conce	ntric		BOM/Route		Grain	Togram		Over/Under	—	Set-up
	Crack		iiiiic	-	Broken/Damage/Defect		Hardwa	ara		Part Incorre	 -	Temperature/Cure
		o/Kink/Rippl	e/Mave		Burrs		4	ion Incomplete/Unqualified	-	Part Lost/Mi	—	Weld
	Cuffs	y Killiky Kilppi	c/ wave		Contamination	\vdash	1 '	tions Incomplete/Unclear	_	Part Moved		Wrong Stock Pulled
	Crush	ing			Countersink	-	4	gned/off center		Positioned V	L_ Vrong	Tarroug stock i diled
	Heat	_		\vdash	Cut Too Short	\vdash	Mislabe	-	\vdash	Power Loss/		Other
		ction Strip ir	n Tube	-	Drawing		Misrea		<u></u>]. 55. 2000/		1
		s/Chatter			Drill Holes		Off-set					
	_	ng Sequence	9		Finish		-	Calibration				
		/Twist in Tu			Fit/Function		-	Sequence				

Work	Order ID	115142

115142

Page 3

Monday, March 17, 2014 2:48:44 PM Accept D3641-3 *N900040100* Item ID: Setup Start **Revision ID:** Stop **Item Name:** Cover Start Qty: 6.00 **Start Date:** 3/17/14 **Cust Item ID:** Required Date: 3/17/14 Req'd Oty: 6.00 **Customer:** Reference: Run Start Process Plan: **Tooling:** Date: **Approvals:** Date: Stop QC: Date: SPC (Y/N): Date: Reject Sequence ID/ Operation Set Up/ **Tool ID** Tool # Plan Accept Reject Insp. Number Work Center ID Description Code **Qty** Qty Stamp **Run Hours** DAS 160 QC7-Inspect Chemical Conversion Coat 0.00 38 9-89 14-9-16 *160* 0.00 Memo Quality Control Identify as per dwg & Stock Location: 57 466 170 *170* 0.00 Packaging Memo Packaging 180 QC21- Final Inspection - Work Order Release 0.00 14/9/179 My.a-16 *120* OC 0.00 Memo Quality Control

DQA:		Date	:									TOACT
					WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE				AEROSPACE
QA Closed:		Date	:						W	ork Order up	odate only	
Work Orde	er:				DISPOSITION			AGAINST	DE	PARTMENT	/PROCESS	
				_	Rework			Skid-tube Crosstube]	Water Jet	Engineering
Part N	lo.				Scrap			Machining Small Fab		Pro	d. Eng. Coor.	Quality
					Use-as-is		Therr	noforming Finishing		Rec/Sto	re/Packaging	Other
NCR N	lo				Suspected Unapproved			Large Fab Composite			Supplier	J L j
Root				Desci	ription of work order update		nitial	Action		Sign &		
Cause	Dat	e Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design												
Doc/Data												
Equip/Tooling												
Handling/Pré												
Material												
Operator										ļ		
Offset/Setup					!							
Process										}		
Supplier												
Training	_							,				
Transport	_											
Unapproved			J								<u> </u>	
المسمال						FAL	ULI CA	TEGORY				
Landir	ng Gear				General Bend		11:-/5	Program		Outside Dim	-ns:-ns	Pressure/Forced
}	Bendi	าย Not Conce	ntric	-	BOM/Route	├	Grain	Togram	-	Over/Under	⊢	
ł	Cracks		entric	\vdash	Broken/Damage/Defect	-	Hardwa	aro.	\vdash	Part Incorre	├	Temperature/Cure
ŀ	_	/ /Kink/Rippl	e/\M/ave	-	Burrs	\vdash	4	ion Incomplete/Unqualified	-	Part Lost/Mi	⊢	Weld
ŀ	Cuffs	miny mppi	c, wave	\vdash	Contamination	<u> </u>	1	tions Incomplete/Unclear	\vdash	Part Moved	-	Wrong Stock Pulled
	Crushi	nø			Countersink		4	gned/off center	\vdash	Positioned V	L Vrong	
	Heat 1	-		<u> </u>	Cut Too Short	<u> </u>	Mislabe			Power Loss/		Other
		tion Strip i	n Tube		Drawing		Misrea		L	J		
		/Chatter			Drill Holes	一	Off-set					
	_	g Sequence	e		Finish		4	Calibration				· · · · · · · · · · · · · · · · · · ·
		/Twist in Tu			Fit/Function		4	Sequence				

Picklist Print

Monday, March 17, 2014 2:48:43 PM

Work Order ID: 115142

115142

Parent Item:

D3641-3

D3641-3

Parent Item Name: Cover

Start Date: 3/17/14

Required Date: 3/17/14

Page 1

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:A New Issue 07-07-20 JLM

Verified By:EC

IPP Rev:B ECN 1050 rev.b as per dwg 08-01-10 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.032		Purchased	No			100	sf	181.8000	0.7851	-4.95 8527	-	DAS	
*M5052H:	325 032	*							**	5		23 9-89	14-09-4

5052-H32 .032 Sheet

Location	Loc Qty	Loc Code	
MAT022	181.8		
116657	22		
117798	3		
121040	3		
m126593	153.8		126593

DQA:			Date:										DART
OA Classide			Data			WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE	144	- O	المستعدات	AEROSPACE
QA Closed:			Date:					-		VV	ork Order up	date only	
Work Orde	er:				,	DISPOSITION			AGAINS	T DE	PARTMENT	/PROCESS	
						Rework			Skid-tube Crosstub	eГ]	Water Jet	Engineering
Part N	lo.					Scrap			Machining Small Fa		Pro	d. Eng. Coor.	Quality
				•		Use-as-is			noforming Finishir	g	-	re/Packaging	Other
NCR N	lo					Suspected Unapproved			Large Fab Composit	e	Supplier		
											-		
Root		,			Desci	ription of work order update		nitial	Action		Sign &		
Cause		ate	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design													
Doc/Data					,	,							
Equip/Tooling	_												
Handling/Pre	_											9	
Material	_												
Operator	_	ł					}						
Offset/Setup	_	Ì											
Process		- 1		Ì									
Supplier 													
Training													
Transport	-										}		
Unapproved	- !	J		<u> </u>			EAI	HT CA	TEGORY				
Landir	ng Gear			-		General	IA	JLI CA	ILGORI				
[ding				Bend		 Folio/E	Program		Outside Dim	ensions [Pressure/Forced
		_	t Concei	ntric		BOM/Route	\vdash	Grain	105.4	\vdash	Over/Under	<u> </u>	Set-up
	Crac					Broken/Damage/Defect		Hardwa	are		Part Incorre		Temperature/Cure
			k/Ripple	e/Wave		Burrs		ł	ion Incomplete/Unqualified		Part Lost/Mi	<u> </u>	Weld
Ì	Cuff	7		,	<u> </u>	Contamination		1	tions Incomplete/Unclear		Part Moved	-	Wrong Stock Pulled
ŀ		shing			_ _	Countersink		ł	ned/off center		Positioned V	∟ Vrong	
		t Treat	t			Cut Too Short		Mislabe			Power Loss/	_	Other
ľ			Strip in	Tube		Drawing		Misread		_	-		
		ks/Cha				Drill Holes		Off-set					
	Turr	ning Se	equence			Finish		Out of	Calibration				
	Wav	/e/Twi	st in Tuk	oe		Fit/Function		Out of S	Sequence				

DART AEROSPACE LTD	Work Order:	115142
Description: Cover	Part Number:	D3641-3
Inspection Dwg: D3641 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.191	+0.005/-0.001	0.193			V	Itmos
0.50	+/-0.030	0.504"	_		J	
4.78	+/-0.030	0.504"	_		V	
0.84	+/-0.030	0.841	_		V	
0.90	+/-0.030	0.90	1		V	
12.42	+/-0.030	12.42"	•		7	Jams 7
22.42	+/-0.030	12.42	•		†	
24.00	+/-0.030	24.00	-		T	
24.84	+/-0.030	24.84	_		1	
			DAS			

	DAS		38		
Measured by:	23	Audited by:	9-89	Preliminary Approval:	
Date:	9-89	Date:	14-9-4	Date:	

Rev	Date	Change	Revised by	Approved
Α	08.12.01	New Issue	KJ/EC/DD	-/-
В	12.03.08	Dwg Rev updated	KJ 9X	

90°±1° TYP ₩ С 3.50 2.50 R0.06 TYP 0.25 ---**D3641-1 COVER** (REPLACES GENEVA P/N G10606-3/-6) (MAKE FROM D3641-1F FLAT PATTERN) REFORMAT DRAWING TO CURRENT STANDARDS; D3641-3 WAS -4 (ZN C4-2); ADD D3641-4 VIEW (ZN A4-2); MOVE -1F/-3F FLAT PATTERN TO SHEET 3. PER NCR 09-076 09.10.02 UPDATE PROFILE TO MATCH TOOLING; GENERAL UPDATE LE 07.10.16 NEW ISSUE; REPLACES G10606 LE 07.07.27 REV. DESCRIPTION BY DATE NOTES:

1) MATÉRIAL: D3641-1F FLAT PATTERN
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3641-1" USING FINE POINT PERMANENT INK MARKER DESIGN DART AEROSPACE USA, INC. DRAWN PORT HADLOCK, WA 115142 MP 14-03-9 DRAWING NO. CHECKED REV. C D3641 MFG. APPR. SHEET 1 OF 3 TITLE

7) WEIGHT: 0.35 lbs

APPROVED

09.10.02

DE APPR.

DATE

COVER

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SCALE

NTS



